

FOR ENGINEERING USE ONLY

Process Sheet

CU-DAR001 Dart Helicopters Services
 : 40394
 : 11972
 P.O. Number :
 This Issue : 09/07/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : R&D SKIDTUBES
 Previous Run : 39756A

Drawing Name : LOW GEAR SKIDTUBE ASSEMBLY 206 A/B

Part Number : D206642141
 Drawing Number : D2660 PROTO
 Project Number : N/A
 Drawing Revision : F H
 Material :
 Due Date : 16/07/2008

Qty: 1 Um: Each

Written By :
 Checked & Approved By :
 Comment : Est Rev:H 05.10.11 ECN 847 & 901; Add Tow Ring and GHW
 Kit; CHG004 KJ/CP/JLM
 Est Rev:I 08-06-10 chg D2654-3 to -1 (seq 13) DD verified
 by:ec

Additional Product

PROTOTYPE

PROTOTYPE

Job Number:



FOR ENGINEERING USE ONLY

Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D206-642-141 CHG001

2.0 D2620 Skidtube, 206 Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
 1 D2620 Bent Tube 3" OD

B29278

M 8-7-9 (2)

3.0 D2647 Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
 1 D2647 Fwd Cap

B35475

QP 8-7-9

4.0 D32861 Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Doubler

B33295

M 8-7-9 (2)

Date: Wednesday, 09/07/2008 12:44:50 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LOW GEAR SKIDTUBE ASSEMBLY 206 A/B

Job Number: 40394

Part Number: D206642141

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Deburr Fwd edge of tube

2- Remove ridge on inside of Fwd edge of tube as per Dwg D2650

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

Pick:

Qty Part Number Description Batch

A/R Aluminum Rod m107877/m108096 8E 8-7-9

4-Grind weld flush to cap on top surface only.

5-Cut Aft end as per dwg 2650 from front of tube and Deburr

6-Remove inner indexing ridge on Aft end of skidtube as per Dwg D2650

7-Open holes for Aft end cap as per Dwg D2650 with #30 Drill Bit using DT8025.

8-Drill pilot holes using Dt 8166 (A,B & C).

9-Locate DT8732 from inner Aft saddle hole & 3rd crossbolt hole. Insert D3286-1 doubler using DT8732 & D206-642-241-T1, then locating doubler off of 3/16" holes, cleco DT8732 & doubler leaving DT8732 for added support.

10- Drill D3286-1 doubler rivet holes in tube using # 40 drill, spot drilling doubler at the same time.

11-Working from the center out, drill # 30 holes into D3286-1 doubler. Cleco each hole as it is being drilled. Verify angle of holes to accommodate rivet heads.

12-Remove and Deburr D3286-1 doubler

13-Remove 3/16" cleco's only and open GHW holes to Ø0.500" as per Dwg D2650

14-Remove D3286-1 doublers, identify orientation, deburr, then attach them to the workorder

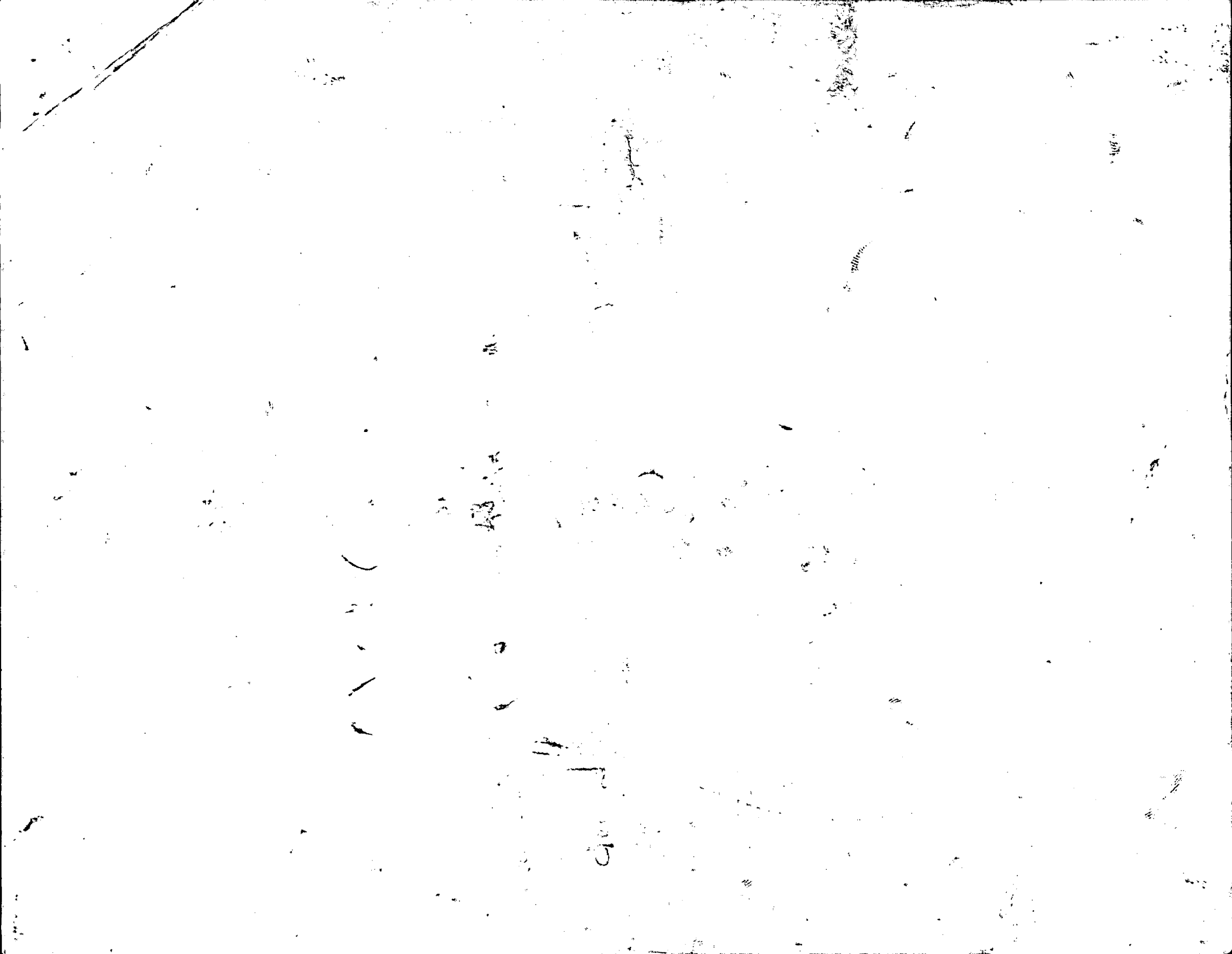
15-Remove indexing edge using DT8741 as per Dwg D2650

16-C'sink GHW rivet holes as per Dwg D2650

) H 8-7-9

H

8-7-10



Date: Wednesday, 09/07/2008 12:44:50 PM
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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

2007-10 (2)

7.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open crossbolt holes as per Dwg D2650

2-Drill pilot holes using DT8028-3, then open to 0.297" as per Dwg D2650. Open Aft cap hole #6.

3-Deburr tube and blow out chips from inside the tube

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M 8-7-10 (2)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BE 8-7-10 (2)

10.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Material Requisitions

Part Number: M7885-3-42

Batch Number: 5799

R/S#: _____

Quantity: 56

Required by: PK Date: 8-7-14

Used for

Part Number: 40394 D206642144

Batch Number: B 40394

Approved by Purchaser: _____

Date: _____

Comments:

Acceptable for this prototype

Date: Wednesday, 09/07/2008 12:44:50 PM
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Process Sheet

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Job Number: 40394

Part Number: D206642141

Number:



Seq. #:	Machine Or Operation:	Description :
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13.0	D26541	Web
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Web

batch:

B40405/B40432 M 8-7-10

14.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Locate, install and rivet doublers as per Dwg D2650. Micro-shave rivets as required

2-Bond D2654-3 web in place as per QSI 015. Ensure holes line up. Allow 12 Hrs. cure time before cutting

Start Date: 08/07/10 Time: 9:05

Finish Date: 08/07/11 Time: 7:44

Pick:

Qty Part Number Description Batch

A/R Sikaflex-291

M 07777

Sikaflex expire date:

8-11-1

M
8-7-10

15.0	QC5	INSPECT WORK TO CURRENT STEP
------	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

Job 07-11 ①
1st tube

08-07-15 ①
2nd tube

16.0	D2649	Cross Bolt Spacer
------	-------	-------------------



Comment: Qty.: 17.0000 Each(s)/Unit Total : 17.0000 Each(s)

Pick:

Qty Part Number Description Batch

17 D2649 Crossbolt spacer

B37859 ⑬

B39883 ⑫ BE 08/07/11
BE 08/07/30
08/07/15
B39883
④
⑪

17.0	D32863	Spacer
------	--------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3286-3

Spacer

B37783

BE 08/07/11

①

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Part Number: D206642141

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Insert D2649 crossbolt spacers. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

Pick:

Qty Part Number Description Batch

A/R Aluminum Rod

M107877

BE 08/07/11

2-Grind welds flush as per Dwg D2650.

M 8-7-11

3-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D2650. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required.

A/RSS Rod

NONE BE 08/07/11

4-Counterbore 5/16" x 0.750" deep except 7th hole from Aft end as per Dwg D2650. Debur

M 8-7-11

19.0

CCR264SS33

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 CCR264SS3-3 Rivets

M106825

Ⓟ M 8-7-11

20.0

M7885343

Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 M7885/3-4-3 Rivets

M102515

Ⓟ M 8-7-11

21.0

D2680041

Nut Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2680-041

Nut Plate B34599

Ⓟ M 8-7-11

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Part Number: D206642141

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Seq. #: Machine Or Operation: Description :

22.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install D2680-041 Nut Plate as per Dwg D2650

M 8-7-11

23.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: Counterbore work to Current Step. Inspect for foreign objects as per QSI 024

2004-16 (2)

24.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-07-15 (2)

25.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

M-1 08/07/17 (2X)

26.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref. 4.3.5.1) as per QSI 005 4.3. Make sure Nut Plate Thread is protected using paint screw, and mask GHW studs.

START TIME: 11:00am

OVEN TEMPERATURE: 320°F

FINISH TIME: 1:30pm

08-07-17

(K)

27.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FD 08/07/17 (1)

28.0 D26483 Wearpad



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 D2648-3 Wearpad

N/A

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Job Number: 40394

Part Number: D206642141

Job Number:



Seq. #:

Machine Or Operation:

Description :

29.0

D265611

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2656-11

Wearshoe

N/A

30.0

D265621

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2656-21

Wearshoe

N/A

31.0

D265631

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2656-31

Wearshoe

N/A

32.0

D34291

Wearpad



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3429-1

Wearpad

N/A

33.0

ALS41032130

Insert



Comment: Qty.: 42.0000 Each(s)/Unit Total : 42.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

42 ALS4-1032-130 Inserts

or (see QSI 017)

N/A

Date: Wednesday, 09/07/2008 12:44:50 PM
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Job Number: 40394

Part Number: D206642141

Job Number:



Seq. #:

Machine Or Operation:

Description :

34.0

AN960JD10L

Washer



Comment: Qty.: 42.0000 Each(s)/Unit Total : 42.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

42 AN960JD10L

Washer

N/A

35.0

MS27039108

Screw



Comment: Qty.: 42.0000 Each(s)/Unit Total : 42.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

42 MS27039-1-08

Screw

N/A

36.0

D26511

Plug



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

16 D2651-1

Plugs

N/A

37.0

D26513

O-Ring



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

16 D2651-3

O-Rings

N/A

38.0

MS27039406

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 MS27039-4-06

Screw

N/A

39.0

AN960JD416

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 AN960JD416

Washer

N/A

N/A

Date: Wednesday, 09/07/2008 12:44:50 PM
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Job Number: 40394

Part Number: D206642141

Job Number:



Seq. #:

Machine Or Operation:

Description :

40.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1]

1- Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.

A/R Sikaflex-291

Sikaflex expire date:

2-Install D2651-3 O-Rings on D2651-1 plugs with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive.

3-Install MS27039-4-06 Screw as per DEO 9153.

NIA

41.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Inspect for foreign objects as per QSI 024

100% 14

42.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2646

Aft Cap

B37755

M-1/BR

(2X)

43.0

MS27039108

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 MS27039-1-08 Screw

M108077

M-1/BR

(4X)

44.0

AN960JD10L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 AN960JD10L

Washer

M104885

M-1/BR

(4X)

M-1/BR 08/07/17

Date: Wednesday, 09/07/2008 12:44:50 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LOW GEAR SKIDTUBE ASSEMBLY 206 A/B

Job Number: 40394

Part Number: D206642141

Job Number:



Seq. #:

Machine Or Operation:

Description :

45.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(2X)

Comment: HAND FINISHING RESOURCE #1

1-Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive

A/R Sikaflex-291

Sikaflex expire date:

M108893
08/10

2-Wing Walk as per Dwg D2650-3 and QSI 005 4.4

Batch:

M108996

M-1/B2 08/07/17

46.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(2X)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL. 17 08/07/17

47.0

QC5

INSPECT WORK TO CURRENT STEP



ENGINEERING
APPROVAL

1060815

SEE W/D
CHG

Comment: INSPECT WORK TO CURRENT STEP

48.0

QC21

FINAL INSPECTION/W/O RELEASE



08/08/2017

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



FOR ENGINEERING USE ONLY

00255

u 08-08-15

PROTOTYPE REQUEST FORM

DART Aerospace Ltd.

Product #: D206-642

Job #: 00255

Date: 08.07.09

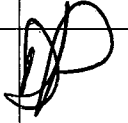
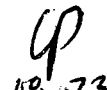
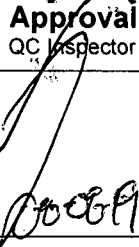
Product Name: Skidtube, 206A/B Low

Requested By: CP

Design Manager Approval: 

Quantity	Part Number	Category	Description	Drawing Date	Material Cert Req'd?	Due Date	Comments	Date Completed
1	D2650-1 D3204-041	LG	Skidtube Assembly	08.07.09	N	ASAP	Same as existing D2650-1, but without wearplate holes	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08.07.30	46.5	ADD ADDITIONAL Ø0.375 HOLE & DZ649 SPACER B/N <u>B39883</u> PER DWG D3804 Rev PROTOTYPE 08.07.30		 8-2-30		 08.07.30 PC QSI 04/2	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

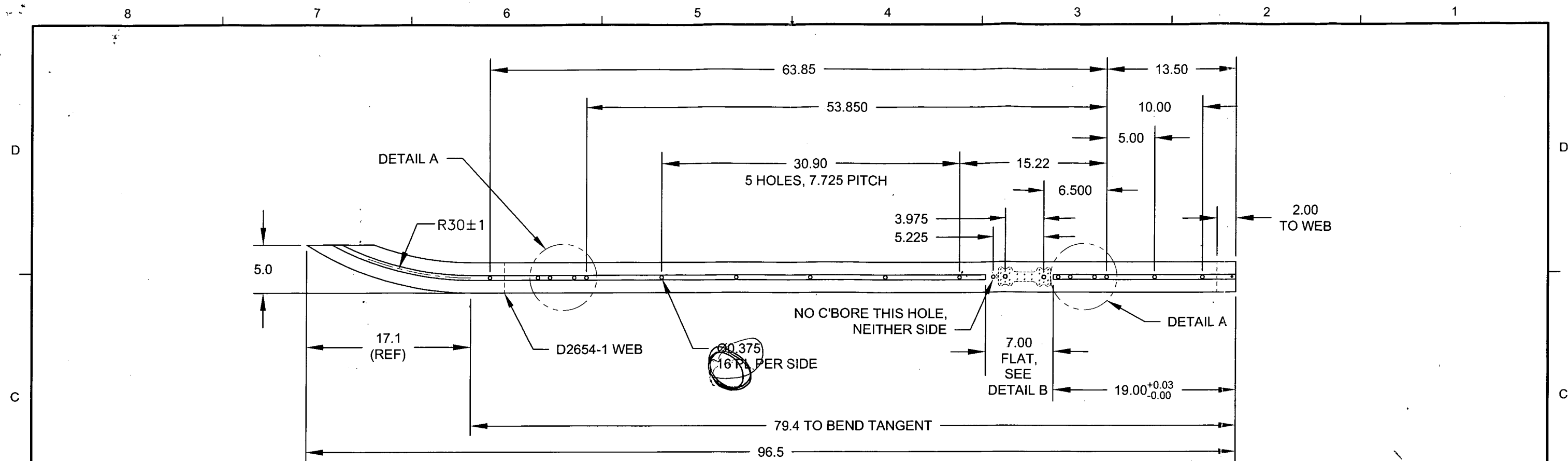
Qty	Part Number	Description
X	D3804-041	SKIDTUBE A
1	D2600-1-160	EXTRUSION
1	D2654-1	WEB
1	D2646	AFT CAP
1	D2647	CAP
16	D2649	CROSS BOLT
16	D2651-1	PLUG
16	D2651-3	O-RING
1	D2680-041	NUT PLATE
2	D3286-1	DOUBLER
2	D3286-3	STUD
2	AN960JD10L	WASHER
2	CCR264SS3-3	RIVET
2	CR3212-4-03	RIVET
2	MS27039-1-08	SCREW
1	MS27039-4-06	SCREW
1	AN960JD416	WASHER
52	CR3212-4-04	RIVET

NOTES

- 1) MATERIAL: PER TABLE ABOVE
- 2) FINISH: -CHEMICAL CONVERSION COAT
-POWDER COAT WHITE (4.3.5.)
-BLACK ANTI-SKID PAINT AS IN DART QSI 005 4.4
- 3) TOLERANCES ARE PER DART QSI 018
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 IN
- 6) IDENTIFICATION: NONE
- 7) WEIGHT:
- 8) WELD PER DART QSI 004
- 9) BENDING: DAMAGE TOLERANCE ON FLEXURE THERE SHOULD BE NO VISIBLE WRINKLES INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO BEND PORTION OF THE TUBE. A MAXIMUM OF 1/8" BENT PORTION OF THE TUBE.
- 10) BOND WEB INTO OUTER TUBE WITH SILICONE
- 11) INSERT D2651-1 PLUG C/W D2651-3 O-RING

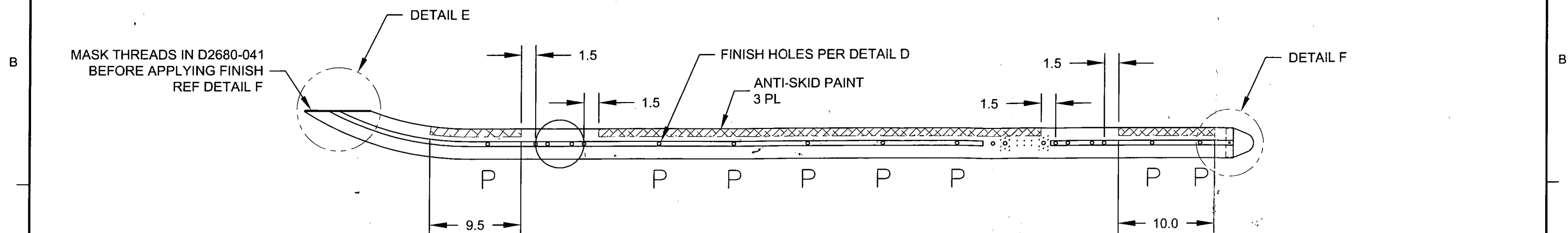
PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
08.07.09

DESCRIPTION		CP	08.07.07
		BY	DATE
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWING NO.		REV. H	
D3804		SHEET 1 OF 4	
TITLE		SCALE	
SKIDTUBE ASSEMBLY, 206A/B LOW		NTS	
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D3804-041 BENDING/DRILLING DETAIL

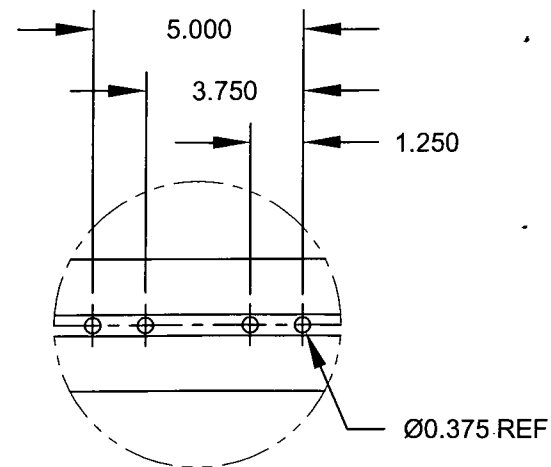
PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
08.07.09 GP



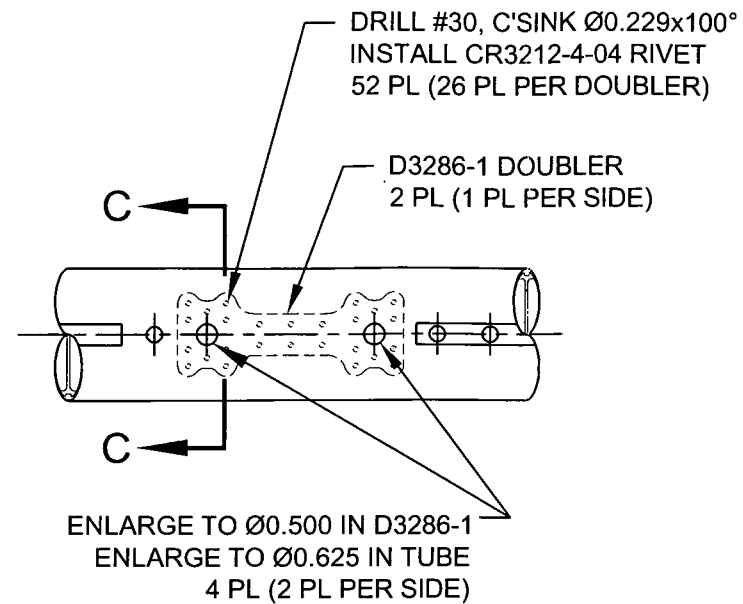
D3804-041 ASSEMBLY/FINISHING DETAIL

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. REV. 1
MFG. APPR.		D2500 SHEET 2 OF 2
APPROVED		TITLE SCAL
DE APPR.		EXTRUSION NT
DATE 08.04.02		COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.

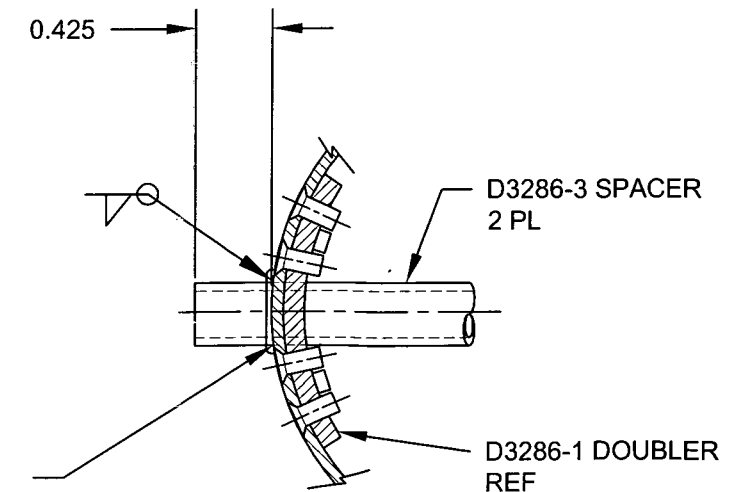
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DETAIL A
NOT TO SCALE

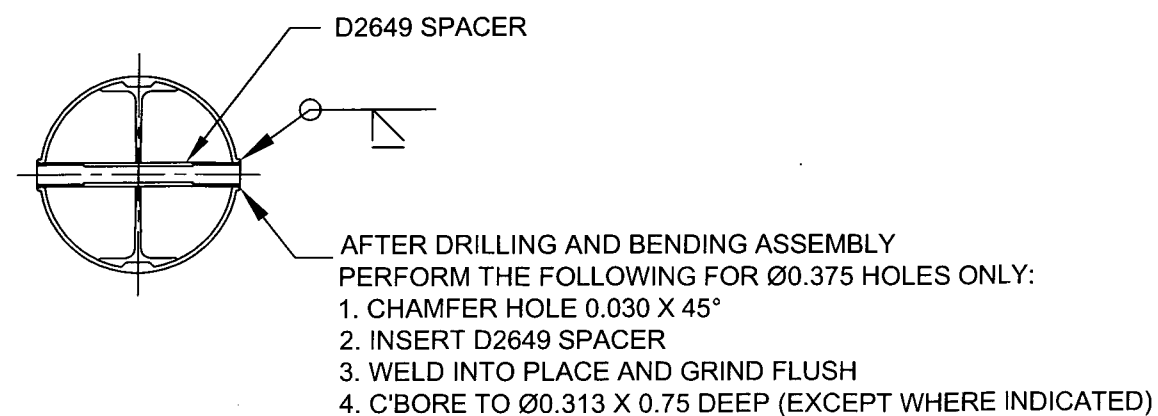


DETAIL B
NOT TO SCALE



- TO INSTALL D3286-1:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH ROUND TUBE
 2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
 3. ENLARGE HOLES IN D3286-1 TO Ø0.500
 4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.030x45°
 5. RIVET D3286-1 TO TUBE
 6. INSERT D3286-3 SPACER
 7. WELD IN PLACE AND GRIND FLUSH

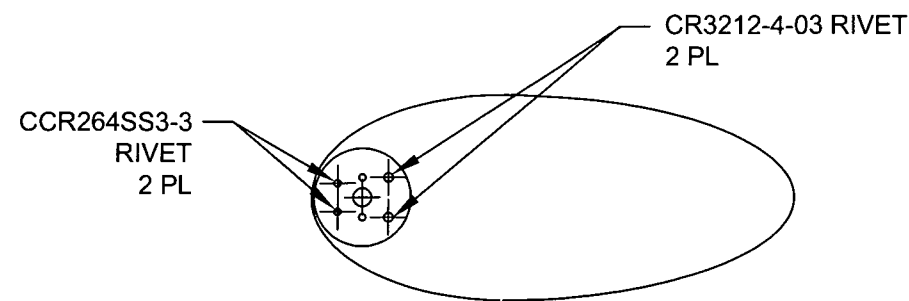
SECTION C-C
PARTIAL SECTION
NOT TO SCALE



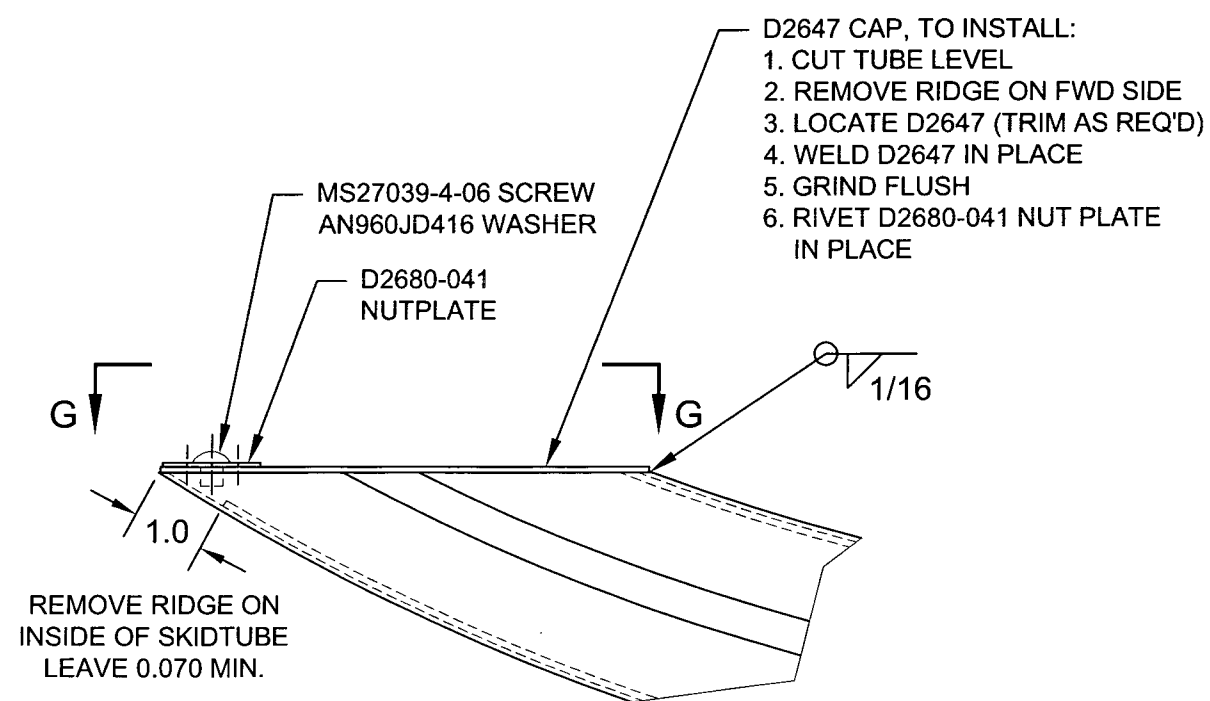
DETAIL D
FOR Ø0.375 HOLES ONLY
- NOT TO SCALE

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
08.07.09 *JP*

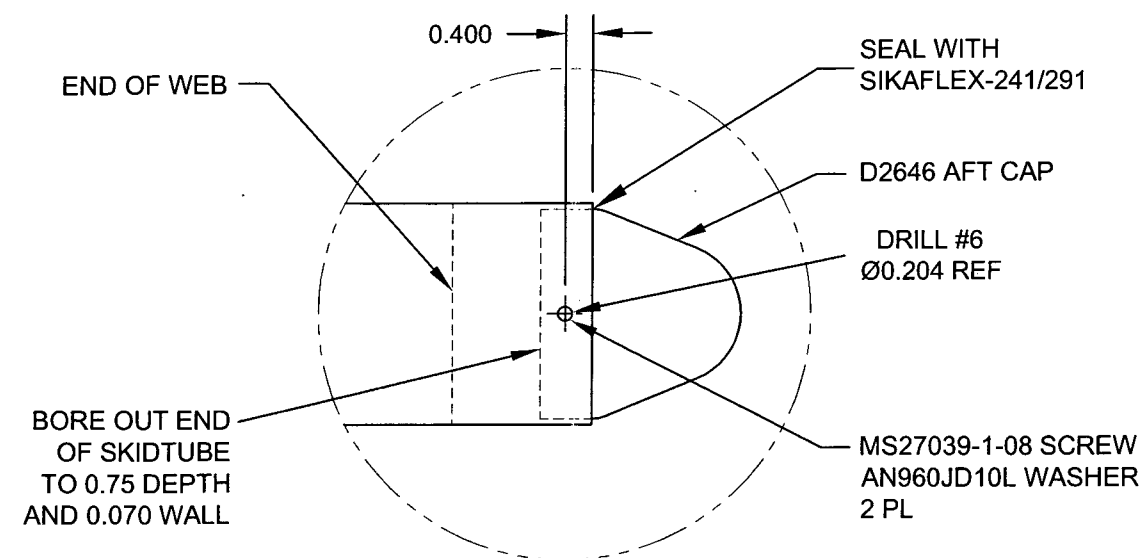
DESIGN		DART AEROSPACE LTD	
DRAWN	<i>JP</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3804	SHEET 3 OF 4
APPROVED		TITLE	SCALE
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VIEW G-G
NOT TO SCALE



DETAIL F
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DETAIL E
NOTE TO SCALE

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
08.07.09 *CP*

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MFG. APPR.		D3804	SHEET 4 OF 4
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